

Date: Monday, 02/03/2009 9:05:02 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET ASSEMBLY
Job Number	: 46140		
Estimate Number	: 10770		
P.O. Number	:	Part Number	: D3462041
This Issue	: 02/03/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3462 REV C
First Issue	: / /	Project Number	: N/A
Previous Run	: 45059	Drawing Revision	: C
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 16/03/2009
Checked & Approved By	: <u>JUD 09.03.02</u>	Qty:	4 Um: Each
Comment	: EST REV. A 05.11.18 NEW ISSUE EC esr rev B 08.07.15 ecn 1049 EC verified by: DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	D34623	Lug
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Flange Pick: Qty Part Number Description Batch 1 D3462-3 flange <u>B45184</u>		
2.0	D34621	BRACKET ASSEMBLY
Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s) Base Flat Pattern Pick: Qty Part Number Description Batch 1 D3462-1F base flat pattern <u>4X-B45017 2XB46286</u>		
3.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
Comment: LARGE FABRICATION RESOURCE 1 Weld assembly as per dwg D3462		
4.0	QC9	VISUAL WELDING INSPECTION
Comment: VISUAL WELDING INSPECTION <u>CP 09.03.16</u>		
5.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP <u>S 09/03/16</u>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 9:05:03 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 46140

Part Number: D3462041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



11110939



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

START TIME:

3:00pm

OVEN TEMPERATURE:

400°F

FINISH TIME:

3:30pm

09-03-19

(X6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-20

(6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 480

9/3/20

S/P

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/03/24

Job Completion



mf 09-03-23

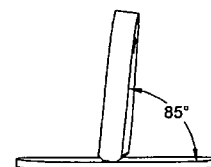
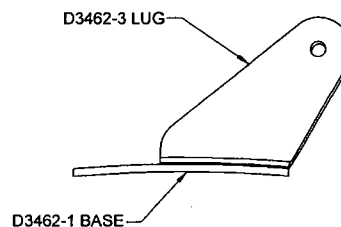
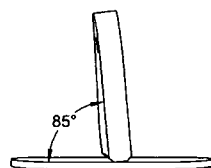
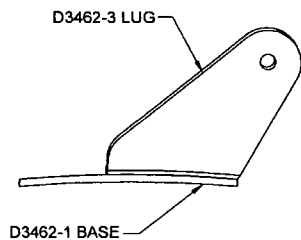
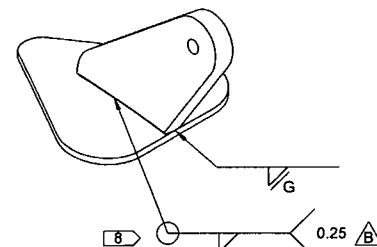
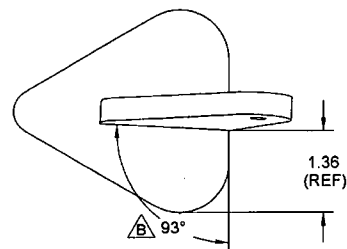
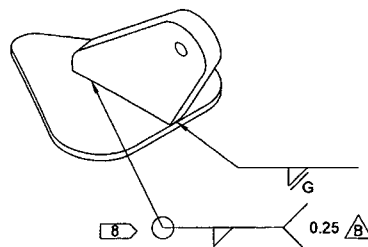
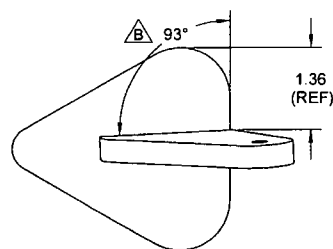
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

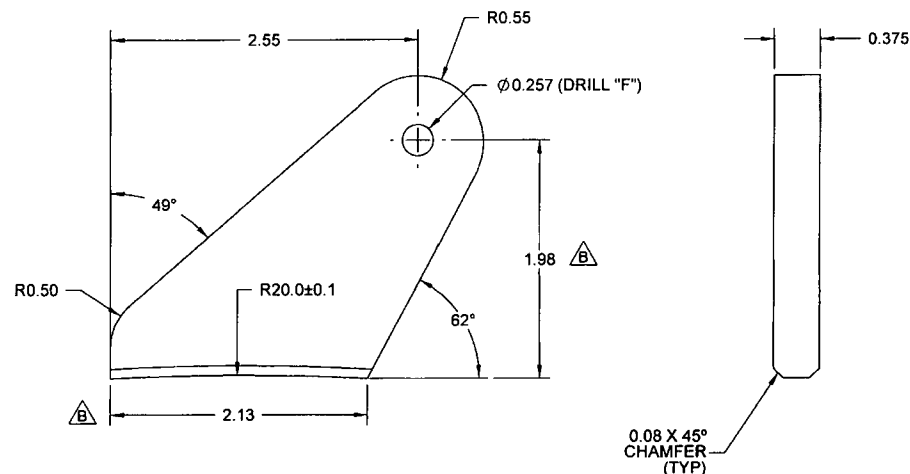
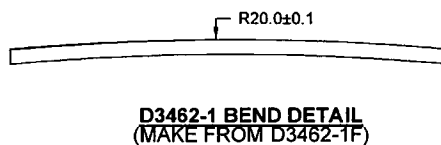
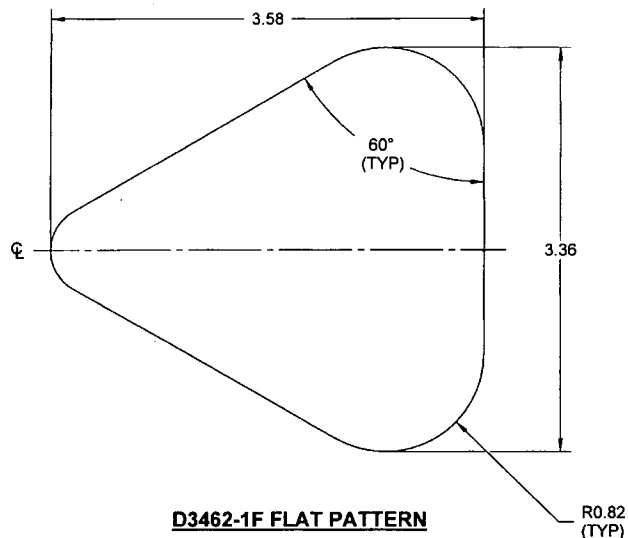
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

RELEASED
06/07/07 14/20

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN	MP, DC		
DRAWN	MP, DC		
CHECKED	MP, DC		
MFG. APPR.	MP, DC		
APPROVED	MP, DC		
DE APPR.	MP, DC		
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 BRACKET ASSEMBLY <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			
		REV. C	SHEET 1 OF 2
		SCALE	1:2

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WITHOUT NOTICE
WORK ORDER
NO. 14440



- NOTES:**
 1) MATERIAL: AISI 304 SS BAR
 (REF. DART SPEC M304B0.375X03.000)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.47 lbs

- NOTES:**
 1) MATERIAL: AISI 304 SS SHEET, 0.125 THICK
 PER MIL-S-5019 (ANNEALED), 2B FINISH
 (REF. DART SPEC. M304S11GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.28 lbs

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RELEASED
8-27-01

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DRAWN	<i>W.D. 7-10-01</i>	DRAWING NO.	REV. C
CHECKED	<i>W.D.</i>	D3462	SHEET 2 OF 2
MFG. APPR.	<i>W.D.</i>	TITLE	SCALE
APPROVED	<i>W.D.</i>	BRACKET ASSEMBLY	1:1
DE APPR.	<i>W.D.</i>	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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